

Work Order ID 127811

December-17-14 1:55:37 PM

127811

Page 1

Item ID: D3572-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Guide

Stop *NS2*

Start Date: 12/17/14 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 12/17/14 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-12-23 Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
-----------------	---------------------

D3572 Rev D

100 Pick Kit

0.00

100

Packaging

0.00

Packaging

110	0.00
-----	------

110

Small Fab

Small Fab

Memo	0.00
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Small Fab

1-Cut Tube D3572-1 as per Dwg D3572
2-deburr both ends

120	QC5- Inspect part completeness to step on W/O	0.00
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120

QC

Memo	0.00
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Quality Control

DAS
38
9-89

JAN 07 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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December-17-14 1:55:37 PM

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Page 2

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Start Date: 12/17/14 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 12/17/14 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>M7128399</u> Large Fab Memo 1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572 2- grind weld flush at the end of tube only	0.00 0.00				<u>4</u>	<u>EL</u>	<u>15-3-16</u>	
140 *140* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				<u>4</u>			DAS 24 9-80 MAR 19 2015
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>4</u>			DAS 24 9-80 MAR 19 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Offset/Setup									
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Training									
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127811

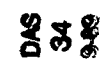
December-17-14 1:55:37 PM

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Page 3

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4		15-3-19	
190 *190* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M 130746.</i> Memo START TIME: <i>9:15</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>9:45</i>	0.00 0.00				4		15-3-23	
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				④			

MAR 23 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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December-17-14 1:55:37 PM

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Page 4

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Revision ID: Stop ***NS2***
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <i>st 288</i>	0.00							
210							DAS		
Packaging	Memo	0.00					27		
Packaging							27		
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

MAR 24 2015

*15/3/26**MF*
15-3-24

DQA: _____ Date: _____



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Picklist Print

December-17-14 1:55:36 PM

Page 1

Work Order ID: 127811

127811

Parent Item: D3572-041

D3572-041

Parent Item Name: Guide

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-02-07 JLM
IPP rev B revB dwg EC
IPP Rev:C Removed D3572-7 Cap 07-06-11 JLM
IPP Rev:D 08-05-27 Review process of IPP DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3572-3		Manufactured	No			130	Each	11.0000	4	16			
D3572-3									**			EL 15-3-16	
Guide													

Location	Loc Qty	Loc Code
127797x5		
WA002	11	
122903	11	

D3572-5		Manufactured	No			130	Each	20.0000	1	4			
D3572-5									**			EL 15-3-16	
Bracket													

Location	Loc Qty	Loc Code
WA001	12	
126311	12	
WA002	8	
122941	8	

M6061T6T1.000W.188		Purchased	No			110	f	328.0000	2.34	10			
M6061T6T1 000W 188									**			FF	
6061T6 RD TUBE 1.00 X .188W													

Location	Loc Qty	Loc Code
GA002	328	
m126686	250	
m128248	78	

JAN 05 2015

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FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <u>FF</u>	Audited by: <u>9-89</u>	Preliminary Approval:
Date: <u>JAN 05 2015</u>	Date: <u>15/07/05</u>	Date:

ev	Date	Change	Revised by	Approved
1	10.04.14	Added preliminary approval	KJ	

10.04.15